



BHARAT HEAVY ELECTRICALS LIMITED

(A Government of India Undertaking)
HIGH PRESSURE BOILER PLANT
PURCHASE DEPARTMENT - FOSSIL BOILERS
THIRUCHIRAPALLI - 620014
TAMILNADU (INDIA)

PHONE :2577645
GRAMS : BHARATELEC
FAX NO: 2520719
E-mail: srchandran@bheltry.co.in
Web:

429-002/A

	Enquiry No	Enquiry Date	Due Date for Quotation
	2691300140 - 41	19.11.2013	17.12.2013
Please quote Enquiry No, Date and due date in all correspondences. This is only a request for quotation and not an order			

Item	Description	Unit	Quantity	Delivery Quantity	Schedule Date
10	<p>Orbital Hot Wirt TIG SPECIAL PURPOSE ORBITAL HOT WIRE TIG WELDING SYSTEM FOR WELDING OF HAND HOLE PIPES TO DISHED ENDS OF HEADER ASSEMBLIES</p> <p>Sr. No,, Particulars and BHEL specification,, Bidder's offer</p> <p>1.0,, Purpose & Application,, 1.1,,1,,The welding equipment is intended to weld pipe to dish end cover butt welding using Orbital Hot wire GTA welding process.</p> <p>a,,Material : Carbon Steel, Alloy Steel, b,,Pipe diameter: 100 - 200 mm c,,Pipe thickness: 10 mm to 25 mm d,,Welding position: 5-G ,, Vendor to confirm</p> <p>2.0,,Scope of Supply,, 2.1,,Orbital Hot wire GTAW equipment's and accessories should consist of the following: 1,,Orbital TIG Welding Power source 2,,Hot wire feeder 3. HOT Wire power source 4,,Controller 5,,Remote Pendant 6,,Orbital TIG welding head (open head) & its accessories. 7,,Water Cooling unit 8,,Inter-connecting cables and hoses. 9,,Spares (Mechanical & Electrical) 10,,General ,, Vendor to confirm</p> <p>2.1.1,,Orbital TIG Welding Power source,, 1,,Inverter type constant current Vendor to confirm power source suitable for TIG welding with continuous current & pulsed current 2,,Input power supply of 3 pH / 415 V / 50 Hz 3,,Output current range: 400 Amps max. 4,,Welding power source duty cycle : 250 amps @ 100% Duty Cycle ,, Vendor to specify</p> <p>2.1.2,,Hot wire feeder 1. HOT wire feeder to feed 1.2 mm wire</p>	NO	1.000	1.00	15.02.14

The offers should reach us 30 minutes before the time of opening of tenders. The offers will be opened at 14.30 hrs on the due date of tender in the presence of tenderers who have submitted their offer and who may like to be present for the tender opening.Late and delayed offers are liable to be rejected.

VIGILANCE AWARENESS WEEK

28 TH OCT-2 ND NOV 2013

FOR VIGILANCE RELATED COMPLAINTS

CONTACT AGM / VIGILANCE

PHONE:0431-2577552,2577636

Yours faithfully,
For **BHARAT HEAVY ELECTRICALS LIMITED**

MANAGER / PURCHASE
(FOSSIL BOILERS)
Yours faithfully,



BHARAT HEAVY ELECTRICALS LIMITED

(A Government of India Undertaking)
HIGH PRESSURE BOILER PLANT
PURCHASE DEPARTMENT - FOSSIL BOILERS
THIRUCHIRAPALLI - 620014
TAMILNADU (INDIA)

Page
2/4

PHONE :2577645
GRAMS : BHARATELEC
FAX NO: 2520719
E-mail: srchandran@bheltry.co.in
Web:

2691300140 / 19.11.2013

- diameter
2. Wire feed speed range
2.1.3 Hot wire power source
1. Hot wire power source type - constant current type
2. Type of current - DC
3. HOt wier duty cycle - 150 A @ 100% Duty cycle
4. Input power - 240V/50Hz/Single phase

Vendor to confirm

- 2.1.4.,,Controllers,,
,,The below mentioned parameters are to be programmable with the offered equipment's.
".,,Pre-purge time /Post purge time
".,,Up slop time / down slop time
".,,Wire start delay / wire stop delay
".,,Rotation start delay / rotation stop delay
".,,Pulsing on / Pulsing off
".,,Oscillation On / Oscillation off
".,,Oscillation dwell time (in/out)
".,,Oscillation width & frequency
".,,Synchronized wire feed with pulsing current
".,,Segmental parameters setting/programming
".,,Pulsing frequency
".,,Inbuilt HF for arc start,,

Vendor to

specify / confirm

- 2.1.5.,,Remote Pendant,,
".,,Remote pendant with high visibility screen and program and trim
minimum parameters of pulsed current, arc voltage, pulsed frequency,
travel speed, oscillation frequency, oscillation width during welding

Vendor to

specify / confirm

- 2.1.6.,,Orbital GTA welding head (open type) & its accessories,,
1.,,Orbital Hot wire welding head
2.,,Water Cooled torch
3.,,Welding torch of rating 250 amps @ 100% Duty Cycle
4.,,Wire diameter: 0.8, 1.0, 1.2 mm
5.,,Tungsten electrode: diameter 1.6, 2.4, 3.2 & 4.0 mm
6.,,AVC travel distance
7.,,AVC maximum speed of the movement
8.,,Wire feeder speed range (mm/min)
9.,,dimensions of welding head
10.,,Estimated weight of the welding head
11.,,Welding head clamping type
12.,,Axial clearance (min) required
13.,,Radial clearance (min)required
14.,,Independent left & right Dwell time range
15.,,Oscillation speed range
16.,,Oscillation width range
17.,,Suitcase type wire feeder (floor mounted type),,

The offers should reach us 30 minutes before the time of opening of tenders.
The offers will be opened at 14.30 hrs on the due date of tender in the presence of tenderers who have submitted their offer and who may like to be present for the tender opening. Late and delayed offers are liable to be rejected.

VIGILANCE AWARENESS WEEK

28 TH OCT-2 ND NOV 2013

FOR VIGILANCE RELATED COMPLAINTS

CONTACT AGM / VIGILANCE

PHONE:0431-2577552,2577636

Yours faithfully,
For **BHARAT HEAVY ELECTRICALS LIMITED**

MANAGER / PURCHASE
(FOSSIL BOILERS)
Yours faithfully,



BHARAT HEAVY ELECTRICALS LIMITED

(A Government of India Undertaking)
HIGH PRESSURE BOILER PLANT
PURCHASE DEPARTMENT - FOSSIL BOILERS
THIRUCHIRAPALLI - 620014
TAMILNADU (INDIA)

Page
3/4

PHONE :2577645
GRAMS : BHARATELEC
FAX NO: 2520719
E-mail: srchandran@bheltry.co.in
Web:

2691300140 / 19.11.2013

Vendor to

specify / confirm
2.1.7 Water Cooling Unit,,
,,Input power supply: 220 V/single phase/AC
,,Cooling tank capacity : min 5.5 L
,,Flow rate : min 4 L/min
,,Pumping pressure or Head: min 4 bar
,,All the hoses are quick release type,,

Vendor to

specify / confirm
2.1.8,,Inter-connecting cables and hoses,,
,,The vendor has to supply the all necessary
inter-connecting cable
and hoses of sufficient
length of quick release type

Vendor to specify

2.1.9,,Spares (Mechanical & Electrical),,
,,1,,List of spares (Mechanical & electrical)
included in the scope of supply should be
mentioned
separately for 2 years trouble free operation.
2,,Unit wise cost of all the items must be
provided
with offer.

Vendor to provide

2.1.10,,General Points,,
,,1,,Vendor has to specify the make and model
of welding machine
2,,Vendor has to provide all the supporting
catalogues
3,,Warranty period for the total system shall be
two years from the
date of commissioning.
4,,Three sets of machine operation manuals
and maintenance and
troubleshooting manuals to be provided.
5,,The system shall have all safety features,
interlocks and alarms.,,

Vendor to specify

2.1.7,,Pre-inspection,,
,,1,,Before dispatch the system, the complete
pre-inspection will be
carried out by BHEL engineer and the welding
trials on mock up job of
similar application at vendors place.
2,,Minimum 2 number of continuous weld joint
should pass the radiograph
quality as per ASME sec IX.
3,,The acceptance criteria for weld quality are
as per BHEL quality
standards.
4,,All the necessary consumable for the PDI
trials to be provided by
the supplier.
5,,The expenditure towards travel & stay of
BHEL engineer will be
under BHEL scope.

The offers should reach us 30 minutes before the time of opening of tenders.
The offers will be opened at 14.30 hrs on the due date of tender in the presence of
tenderers who have submitted their offer and who may like to be present for the tender
opening.Late and delayed offers are liable to be rejected.

VIGILANCE AWARENESS WEEK

28 TH OCT-2 ND NOV 2013

FOR VIGILANCE RELATED COMPLAINTS

CONTACT AGM / VIGILANCE

PHONE:0431-2577552,2577636

Yours faithfully,
For **BHARAT HEAVY ELECTRICALS LIMITED**

MANAGER / PURCHASE
(FOSSIL BOILERS)
Yours faithfully,



BHARAT HEAVY ELECTRICALS LIMITED

(A Government of India Undertaking)
HIGH PRESSURE BOILER PLANT
PURCHASE DEPARTMENT - FOSSIL BOILERS
THIRUCHIRAPALLI - 620014
TAMILNADU (INDIA)

Page
4/4
PHONE :2577645
GRAMS : BHARATELEC
FAX NO: 2520719
E-mail: srchandran@bheltry.co.in
Web:

2691300140 / 19.11.2013

Vendor to confirm
2.1.8,,Installation & commissioning,,
,,1,,Installation and commissioning of the
system to be done at BHEL,
Trichy shop by the vendor.
2,,After successfully commissioning of the
system prove out welding
trials to be carried out to establish the process
parameter for actual
job. At least five pipe joint should welded
meeting NDT requirements
3,,Vendor has to provide training to BHEL
engineers &
technicians' in operation and maintenance of the
system for three days
at BHEL Trichy,,

Vendor to confirm
Orbital Hot Wirt TIG

General Note:

PL. SUBMIT YOUR OFFER ON F.O.R - BHEL, TRICHY (TAMILNADU), INDIA / FCA -
BHEL, TRICHY (TAMILNADU), INDIA BASIS AND IN TWO PART (TECHNO-COMMERCIAL
BID AND PRICE BID) IN A SEPARATE COVER.

IF THE OFFER IS SUBMITTED IN SIGNLE PART AND THE SAME WILL BE LIABLE FOR
REJECTION.

ANNEXURE-III ENCLOSED HEREWITH MUST BE FILLED, SIGNED AND SUBMITTED
ALONG WITH YOUR OFFER.

WE MAY GO FOR REVERSE AUCTION (ONLINE BIDDING) IF REQUIRED FOR THIS
TENDER.

THIS TENDER IS HOSTED IN BHEL WEBSITE VIDE NIT REF. _____ DT. _____
AND ANY CORRIGENDUM MAY PL BE VIEWED IN THE BHEL WEBSITE (HTTP://
WWW.BHEL.COM)

ENCLOSURE: ANNEXURE - III

Enclosures:

"LD clause has to be confirmed without fail."

The offers should reach us 30 minutes before the time of opening of tenders.
The offers will be opened at 14.30 hrs on the due date of tender in the presence of
tenderers who have submitted their offer and who may like to be present for the tender
opening.Late and delayed offers are liable to be rejected.

VIGILANCE AWARENESS WEEK

28 TH OCT-2 ND NOV 2013

FOR VIGILANCE RELATED COMPLAINTS

CONTACT AGM / VIGILANCE

PHONE:0431-2577552,2577636

Yours faithfully,
For **BHARAT HEAVY ELECTRICALS LIMITED**

MANAGER / PURCHASE
(FOSSIL BOILERS)
Yours faithfully,

MM: CAPITAL EQUIPMENT

Bharat Heavy Electricals Limited, Trichirapalli – 620 014
(To be filled and submitted along with Offer)

BHEL Enquiry No.:

Date:

BHEL Commercial Terms and Conditions for IMPORT SUPPLIES	Vendor's Confirmation/ Comments
Technical confirmation to BHEL's Specification as called for in BHEL Format shall be furnished. If needed additional sheets shall be used.	To be furnished along with offer
Prices shall be quoted item wise only.	
Prices shall be quoted on " FIRM PRICE " basis only. The prices should be only on FOB/FCA basis inclusive of Packing & Forwarding charges if any.	
Validity of offer shall be for a minimum period of 120 days from the date of Tender opening	
Delivery period from the date of Letter of Intent shall be clearly mentioned in the offer.	
Liquidated damages @ ½% per week subject to a maximum of 15% of the order value shall be applicable for delay in deliveries.	
Payment terms for Foreign vendor (Principal): 100% value of the goods will be paid through an irrevocable Letter of Credit established by our bankers. (OR) 100% payment on CAD (CASH AGAINST DOCUMENTS) BASIS All bank charges outside India are to vendor's account only. Any advance payment or payment before dispatch is not acceptable to us and If you fail to accept our payment terms, your offer is liable for rejection.	
Payment terms for Indian Agent: Indian Agency commission, if any, shall be clearly specified in the offer and the same will be paid in Indian Rupees against acceptance / commissioning of the equipment.	
Part Shipment or Transshipment is not permissible	
In case of any short shipment in the spares, where separate rates are not available in the contract, the customs duty levied on such supplies, shall be borne by the supplier / Indian agent.	
Any warranty replacement during warranty period shall be supplied free of charge on FOR BHEL, Trichy basis.	
Equipment will be inspected and proved at vendor's works prior to dispatch. However final inspection and acceptance of equipment will be after installation at BHEL, Trichy.	
The equipment shall be guaranteed for a period of 12 months from the date of commissioning.	
Offers should be submitted only in sealed cover superscribing clearly the Enquiry reference and due date.	

NOTE:-

- a) It is confirmed that all the terms and conditions stipulated in the Enquiry have been fully understood by us and all clarifications & details have been obtained.
- b) The prices are to be offered only on FOB/FCA basis, inclusive of Packing & Forwarding charges if any.
- c) Your specific acceptance to BHEL Payment terms & LD are essential for consideration of your offer. Otherwise your offer is liable for rejection.

Signature & Office Seal of the vendor

Bharat Heavy Electricals Limited, Trichirapalli - 620 014

MM : CAPITAL PURCHASE

(To be filled and submitted along with offer)

BHEL Commercial Terms and Conditions for Indigenous Supplies	Vendor's Confirmation / Comments
Technical confirmation to BHEL's Specification as called for in BHEL Format shall be furnished. If needed additional sheets shall be used.	
Prices shall be quoted item wise only as per the model format enclosed.	
Prices shall be quoted on " FIRM PRICE " basis only. The prices should be only on F.O.R / Despatching station basis inclusive of Packing & Forwarding charges if any. Applicable % of ED & Sales Tax , Freight & Insurance, Installation & Commissioning Charges should be clearly indicated.	
Validity of offer shall be for a minimum period of 120 days from the date of Tender opening	
Delivery period from the date of Letter of Intent / Purchase order shall be clearly mentioned in the offer.	
Liquidated damages (at % per week subject to a maximum of 15% of the order value shall be applicable for delay in deliveries.	
Following Risk Purchase clause shall be applicable: The purchaser at his option will be entitled to terminate the contract and to purchase elsewhere at the risk and cost of the seller either the whole of the goods or any part which the supplier has failed to deliver or dispatch within the time stipulated or if the same were not available, the best and the nearest available substitute therefore. The supplier shall be liable for any loss which the Purchaser may sustain by reason of such risk purchases.	
Payment terms for supply portion: <ul style="list-style-type: none">• 100% payment will be made within 45 to 90 days after receipt and acceptance / commissioning of goods at BHEL. against submission of PBG for 10% of Order value with required validity. (or)* 80% value of the goods will be paid within 45 to 90 days against dispatch documents, negotiated through bank. Balance 20% will be paid within 45 to 90 days from the date of acceptance / commissioning of goods against submission of supplementary invoice and also against submission of PBG for 10% of Order value with required validity. All bank charges are to vendor's account only.	
Erection / commissioning: Erection / commissioning shall be done at free of cost.	
The equipment shall be guaranteed for a period of 12 months from the date of commissioning.	
Equipment will be inspected and proved at vendor's works prior to dispatch. However final inspection and acceptance of equipment will be after installation at BHEL, Trichy.	
The vendor shall provide necessary drawings, Test Certificates and Operating Maintenance Manuals etc., as called for in the Technical Specification, in the required number of copies at no extra cost.	
Any warranty replacement during warranty period shall be supplied free of charge on FOR BHEL, Trichy basis.	
Offers should be submitted only in sealed cover super-scribing clearly the Enquiry reference and due date.	

NOTE:-

- a) It is confirmed that all the terms and conditions stipulated in the Enquiry have been fully understood by us and all clarifications & details have been obtained.
- b) Your offer should be indicating applicable if any P&F Charges, % of ED, Sales Tax -CST or VAT, Service Tax), Freight, Insurance and Installation and Commissioning Charges etc., as per our Price Format.
- c) Your specific acceptance to our Payment terms, LD, Risk Purchase Clause & Submission of PBG for 10% of the order value are essential for consideration of your offer. Other wise your offer is liable for rejection.

Signature & Office Seal of the vendor

7